## Claims

[c1]

1. A container closure for a container comprising:

a top;

an annular side wall extending from the top, the side wall having an internal thread adapted to engage with threads of the container around a container opening; and

a tamper-evident portion on a lower portion of the side wall, the tamper-evident portion including a plurality of leaders extending across a score line to a lower band, the lower band including a substantially continuous internal projection below the leaders, wherein the projection includes an angled portion for a portion of the circumference forming a lead-in thread for the projection.

[c2]

2. The closure as claimed in claim 1 wherein the angled portion extends for about ninety degrees of the circumference.

[c3]

3. The closure as claimed in claim 2 further including a plug seal on the top, wherein the angled portion includes a rounded end, and wherein the angled portion is angled in the same direction as the threads on the side wall.

[c4]

4. The closure as claimed in claim 1 wherein the projection is a rib having a length-to-width ratio of at least one and one-half.

[c5]

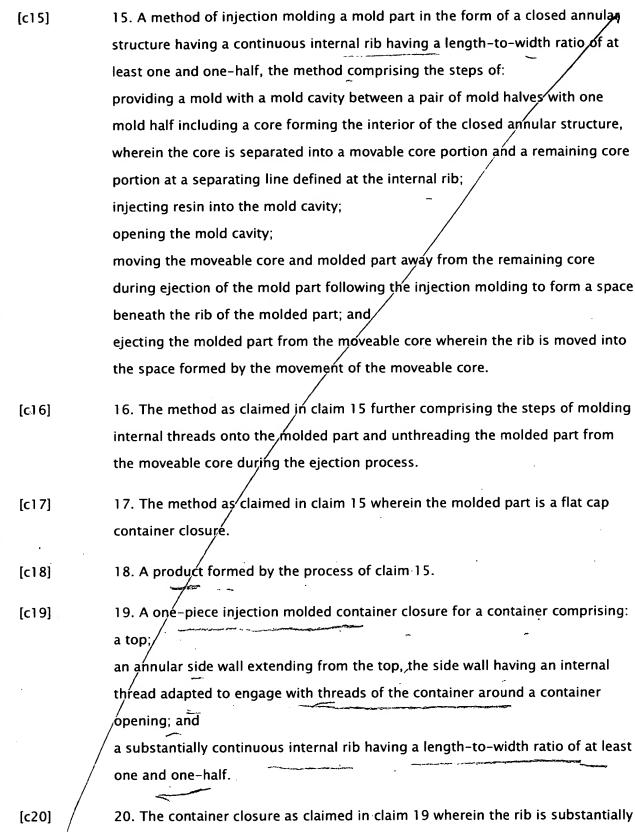
5. The closure as claimed in claim 4 wherein the rib is substantially rectangular in cross-section, has a length-to-width ratio of at least two, and is angled away from the top.

[c6]

- 6. A tamper-evident portion for a container closure wherein the tamper-evident portion is on a lower portion of the side wall of the container closure, the tamper-evident portion comprising:
- a lower band:
- a score line between the lower band and the side wall of the container closure; a plurality of leaders extending across the score line between the lower band and the side wall of the container to connect the lower band to the side wall; and
- a substantially continuous internal projection on the lower band below the

leaders, wherein the projection includes an angled portion for a portion of the circumference forming a lead-in thread for the projection.

- [c7] 7. The tamper-evident portion as claimed in claim 6 wherein the angled portion extends for about ninety degrees of the circumference.
- [c8] 8. The tamper-evident portion as claimed in claim 6 wherein the projection is a rib having a length-to-width ratio of at least one and one-half and wherein the angled portion includes a rounded end.
- [c9] 9. The tamper-evident band as claimed in claim 6 wherein the rib is substantially rectangular in cross-section, has a length-to-width ratio of at least two, and is angled away from the leaders.
- [c10] 10. An injection mold for forming a mold part in the form of a closed annular structure having a continuous internal rib having a length-to-width ratio of at least one and one-half, the mold including a core forming the interior of the closed annular structure, wherein the core is separated into a movable core portion and a remaining core portion at a separating line defined at the internal rib, wherein the moveable core is moveable away from the remaining core during ejection of the mold part following the molding process wherein a space is formed for the rib to move into during the ejection process by the movement of the moveable core.
- [c11] 11. The mold as claimed in claim 10 wherein the core forms internal threads on the molded part.
- [c12] 12. The mold as claimed in claim 11 wherein the core forms a tamper-evident portion in the molded part.
- [c13] 13. The mold as claimed in claim 1.2 wherein the rib is a retaining element for the tamper-evident portion.
- [c14] 14. The mold claimed in claim 11 wherein the molded part is a flat cap with internal threads and a tamper-evident portion and wherein the core forms the internal threads and leaders for the tamper-evident portion, and the rib is part of the tamper-evident portion.



rectangular in cross-section, has a length-to-width ratio of at least two, and is

angled away from the top.